

Work Order ID 52930

October 19, 2009 10:59:01 AM

Page 1

Item ID: D3816-3

Accept

Revision ID: A

Item Name: Spacer

Start Date: 10/19/09 Start Qty: 32.00

Required Date: 11/02/09 Req'd Qty: 32.00

Reference:

Approvals:

Process Plan:

Date: 09/10/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3816

Rev A

100



Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA785 Rev: A & Dwg D3816 Rev: A □2-Deburr per dwg D3816

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00



09/10/20

40

09/10/20

40

09/10/20

40

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Page 2

Item ID: D3816-3

Accept

Revision ID: A

Item Name: Spacer

Start Date: 10/19/09 Start Qty: 32.00

Required Date: 11/02/09 Req'd Qty: 32.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

BR 09-10-20

40



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

QND 09/10/20

X40



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 133

0.00



Packaging

Memo

0.00

Packaging

Ref 10/21 (40)

Work Order ID 52930

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Item ID: D3816-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacer

Start Date: 10/19/09 Start Qty: 32.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 32.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/21 *[Signature]*
ME
09-10-21

Picklist Print

October 19, 2009 11:01:25 AM

Page 1

Work Order ID: 52930

Parent Item: D3816-3RevA

Parent Item Name: Spacer


Comments:

Start Date: 10/19/09

Required Date: 11/02/09

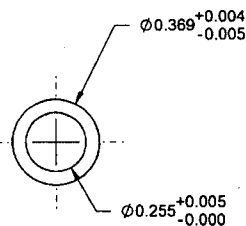
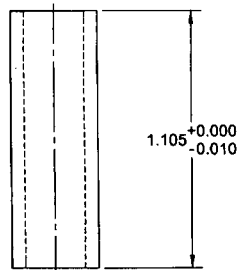
Start Qty: 32.00

Required Qty: 32.00

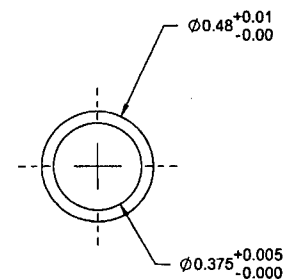
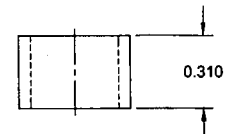
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No			100	f	54.1970	1.0442			
												
6061-T6 Round Bar .500"												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	54.197	
110532	36	
111448	18.197	

1.043 SN 09/10/20



D3816-1 SPACER



D3816-3 SPACER





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WITHOUT NOTICE
WORK ORDER
NO. 52930
PL 09-10-10

RELEASE
09/01/17

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3816-1/-3 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3816-1 0.01 lbs
D3816-3 0.01 lbs

A NEW ISSUE		BY  DATE 08.09.17	
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3816	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
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